

Work Order ID 72027

Monday, July 18, 2011 9:56:51 AM



Page 1

Item ID:	D3443-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Strut Weldment Assembly				Stop	
Start Date:	7/18/2011	Start Qty: 3.00				
Required Date:	7/25/2011	Req'd Qty: 3.00				
Reference:						

Approvals:	Process Plan:		Date: 11-07-18	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3443								
110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

EZ 11-11-28

PC 11-11-29

4x

11-11-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Page 2

Accept

Setup Start

Stop

11-00000

Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

1-Mask holes as per dwg D3443

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

0.00

3:45^{0.00}
4000 F

4.15

140

QC3- Inspect Part Finish

0.00



QC

QC

Memo

0.00

Quality Control

150

0.00



Small Fab

Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble bearing and ball plungers as per dwg D3443 using DT9518

Ensure bearing rotates smoothly

420 m. L 4/11/20

H BR 11-11-20

EP 11/11/30 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date:	7/25/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC5- Inspect part completeness to step on W/O	0.00				<u>11</u>	<u>11</u>	<u>11</u>	<u>30</u>
QC Quality Control	Memo	0.00							(4)
170 	Identify as per dwg & Stock Location: <u>198A</u>	0.00							
Packaging Packaging	Memo	0.00				<u>11/11/30</u>		<u>51(4)</u>	
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00						<u>11/12/1</u>	

W 11-16-30

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Monday, July 18, 2011 9:56:58 AM

Page 1

Work Order ID: 72027

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly





Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3443-1  Lug		Manufactured	No			100	Each	4.0000	1	3			
<div> <div>72033x2</div> <div>73613x2</div> </div> <div> <div>Location</div> <div>WA</div> <div>70596</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3443-5  Tubing		Manufactured	No			100	Each	3.0000	1	3			
<div> <div>73099x4</div> </div> <div> <div>Location</div> <div>WA022</div> <div>69761</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3453-1  Clevis		Manufactured	No			100	Each	4.0000	1	3			
<div> <div>73470</div> </div> <div> <div>Location</div> <div>ST058</div> <div>71203</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3965-4  Bearing, Spherical		Manufactured	No			100	Each	12.0000	1	3			
<div> <div></div> </div> <div> <div>Location</div> <div>ST100</div> <div>71181</div> </div> <div> <div>Loc Qty</div> <div>12</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

EL 11-11-08

EL 11-11-08

EL 11-11-08

EL 11/11/30

B73614 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, July 18, 2011 9:56:58 AM

Work Order ID: 72027



Parent Item: D3443-041



Parent Item Name: Strut Weldment Assembly

Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 3.00

Required Qty: 3.00

D3966-4-750

Manufactured No

100

Each

32.0000

2

6



12-11-28

Pin, Dowel

Location

Loc Qty

Loc Code

ST100

32

58711

32

73566 x7

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

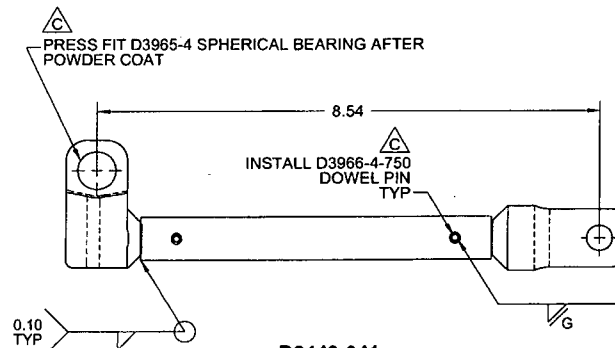
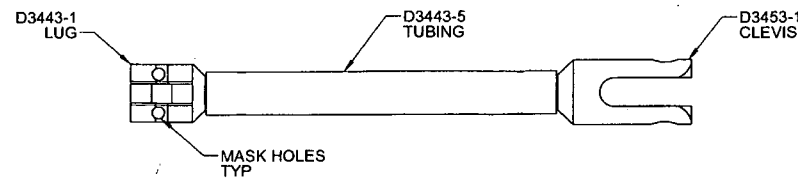
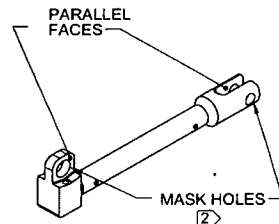
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72027
PL 11-07-18

RELEASED
09/08/25 MP

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER P/N (ZN C6-1, B5-2); D3966-4-750 WAS McMASTER-CARR P/N (ZN B5-1); REF PAR 08-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>UP</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>[Signature]</u>	D3443	SHEET 1 OF 4
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

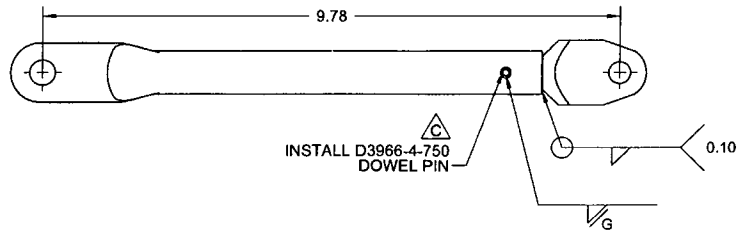
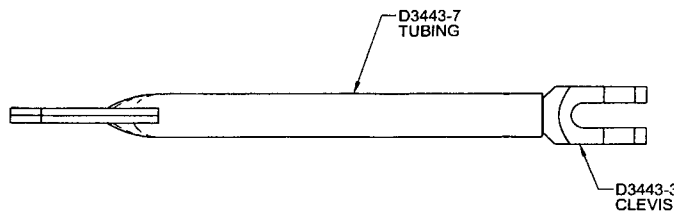
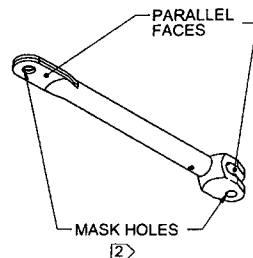
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

12027

RELEASED
09/06/25

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.97 lbs
 - 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UP	DRAWING NO. D3443	REV. C
MFG. APPR.		SHEET 2 OF 4	
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DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
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8 7 6 5 4 3 2 1

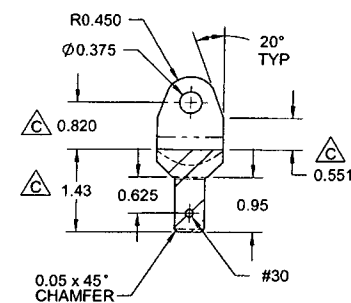
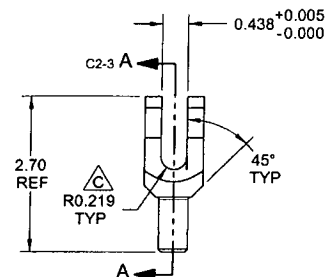
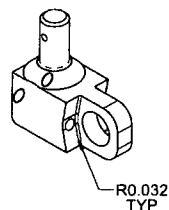
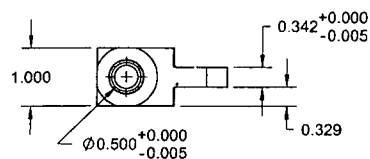
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

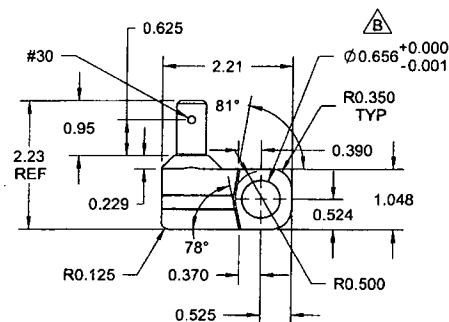
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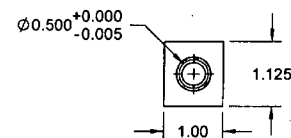
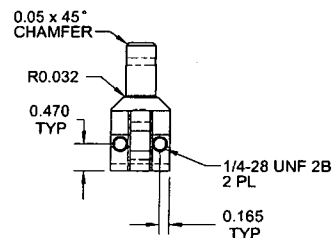
NOTE: Date & initial all entries



SECTION A-A C4-3



D3443-1 LUG





D3443-3 CLEVIS

RELEASED
09/08/25/14

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
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DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
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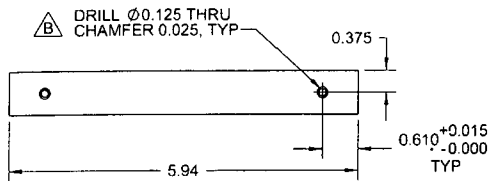
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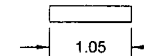
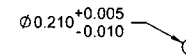
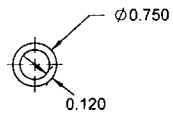
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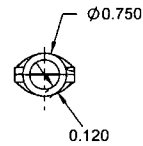
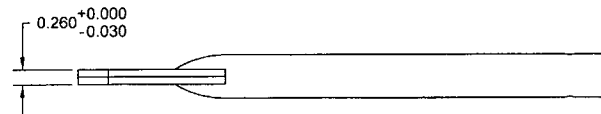
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D3443-5 TUBING

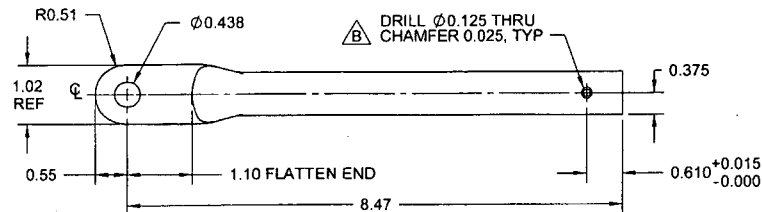


D3443-9 PIN



D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

RELEASED
01/28/25 M2

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	97	DRAWING NO. D3443	REV. C
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE	SCALE
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Dart Aerospace Ltd

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